

Work Order ID 161850

Thursday, June 08, 2017 1:59:41 PM

161850

Page 1

Item ID: D6201

Revision ID:

Item Name: "T" Extrusion

Start Date: 5/12/2017 Start Qty: 20.00

Required Date: 5/23/2017 Req'd Qty: 20.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

20***20***DAS
13
5-89

Approvals: Process Plan: _____ Date: JUN 08 2017 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6201	Rev A

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 36633

0.00

20

JUN 09 2017

DAS
13
9-89

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

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Item ID: D6201 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: "T" Extrusion
 Start Date: 5/12/2017 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/23/2017 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.40							
Packaging	Ensure material certification is attached								
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6201								
130	Identify as per dwg & Stock Location: MAT 028	0.00							
130									
Packaging	Memo	0.20							
Packaging	LOCATION: MAT028								

20ft Sp17-6-15

(20) 17-06-19 DAS 9 9-89

20ft 17-06-19 B.F.

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Item ID: D6201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: "T" Extrusion

Start Date: 5/12/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/23/2017 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

2.00

Quality Control

JUN 19 2017

Picklist Print

Thursday, June 08, 2017 1:59:39 PM

Page 1

Work Order ID: 161850

161850

Parent Item: D6201

D6201

Parent Item Name: "T" Extrusion

Start Date: 5/12/2017

Required Date: 5/23/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: 01.05.15New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201P		Purchased	No			110	f	0.0000	1	20			
D6201P									**				
T Extrusion 4X4X3/8													

doft 5/17-6/5

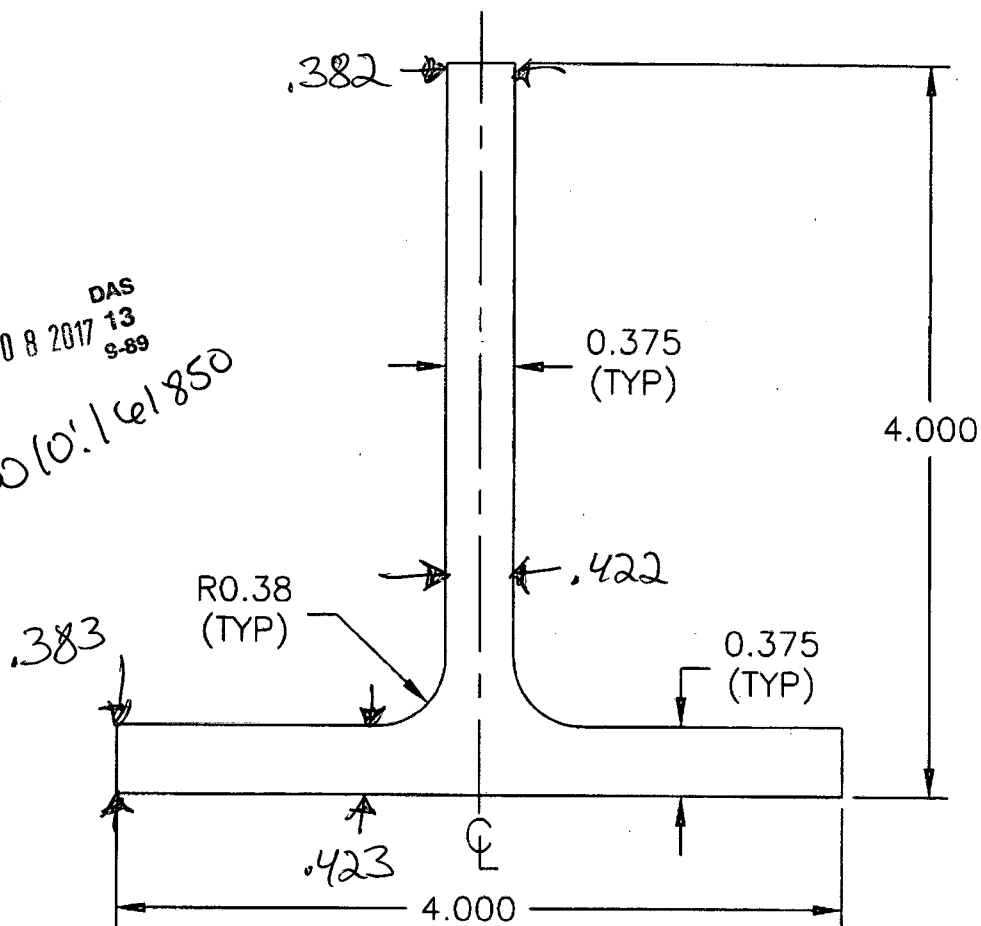


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23

DAS
JUN 08 2017 13
9-89
W10161850



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36633

Purchase Order Date 6/9/2017 10:51:00 AM

PO Print Date 6/9/2017

Page Number 1 of 2

Order From :

VC-CAM002

Ship To : DART AEROSPACE LTD

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RE-MAILED
10-11-17

Revised \$

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6201P AS PER DWG D6201 REV. A B161850	T Extrusion 4X4X3/8	6/14/2017 Yes 6/14/2017		20.00 f	\$23.00	\$460.00
Line Total:							\$460.00
3	M304SI4GA PURCHASE MATERIAL: AISI 304/316 SS SHEET ANNEALED SPECIFICATION: MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) ORASTMA240 OR ASME SA240	304SS sheet .080	6/14/2017 Yes 6/14/2017		64.00 sf	\$8.36	\$535.35
Line Total:							\$535.35

Note:

6/9/2017



DELIVERY - CLIENT

CO00035109

ACIER OUELLETTE INC.

935, Boul. du H vre
Salaberry de Valleyfield (Qu bec) J6S 5L1
T l.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Customer N  CLI0001056
Date 2017/06/09
Delivery date **2017/06/13**
Your order N  36633
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days
Page 1

Billed to
DART AEROSPACE LTD
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

, Ontario,

Att : CHANTAL LAVOIE T l.: 613-632-5200

Instruction F-M

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 T-BAR ALU 4 X 4 X 3/8 (20) TBAL-4438-20 6433 1 X 20' HEAT:	68.60	1.00	UN		1420'						
2017-6-15											

Conditions :

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Total Weight (Lbs) : 68.60**NIR :** R-109516-6

Prepared By :	Verified By :	Delivered By :	Time		Y	M	D
				Customer's Signature	Date		

Total (\$CAD)

**ACIER OUELLETTE INC.**

935, Boul. du Hâvre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Order - Sales**Copy**

CO00035109

Billed to

DART AEROSPACE LTD
»0.xpl
+0

Shipped to

, Ontario,

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Delivery Route

5

Customer N°

CLI0001056

Date

2017/06/09

Delivery date**2017/06/13****Your order N°**

36633

Processed by

Josianne Bourdon

Salesman**Carrier**

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Page

1

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 T-BAR ALU 4 X 4 X 3/8 (20) TBAL-4438-20 6433 1 X 20' HEAT:852198 DAS 9 9-89	1 372.00	1.00	UN	1.00							

2017-6-15

Total Weight (LBS) : 1 372.00**NIR : R-109516-6****Conditions :**

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, out or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Prepared By :	Verified By :	Delivered By :	Time	Customer's Signature	Y	M	D

Total (\$CAD)**519.80****Deposit****0.00****Balance****519.80**



SIGNATURE ALUMINUM CANADA
1850 CLEMENTS RD
PICKERING, ON L1W 3R8

C129820
CERTIFICATE OF COMPLIANCE

05/31/2015	5357009	118418	1
PO97565	020743	652188 <i>sample</i>	05/31/15

42081
A S A ALLOYS INC.
81 STEINWAY BOULEVARD
ETOBICOKE, ON M9W 6H6
CANADA

42081
A S A ALLOYS INC.
81 STEINWAY BOULEVARD
ETOBICOKE, ON M9W 6H6
CANADA

002	C-031522-10	240" MILL 8081 T651T	3/8X4X4" TEE ALUMINUM
	774 LBS		
	752 LBS	11 PCS	1 PKGS
ASTM B221-03	DAS 9		

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI		N/A	
334.5 / 48.5	304.2 / 44.1	15.4		92

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.00	0.24	0.19	0.06	0.87	0.06	0.06	0.02	0.01	0.00

DAS
14
9-89

17/06/16

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealuminum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6201
 DATE: 17/06/16

PO / BATCH NO.: 30633/161850

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 20'
 QUANTITY INSPECTED: 20'
 QUANTITY REJECTED: _____

THICKNESS ORDERED: .375
 THICKNESS RECEIVED: .390
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒	
CORRECT FINISH	☒ N	
CORROSION	Y ☒	
CORRECT GRAIN DIRECTION	☒ N	
CORRECT MATERIAL PER M-DRAWING	☒ N	AMS 20-A-200/8
CORRECT THICKNESS	☒ ☒	
PHOTO REQUIRED	Y ☒	
CORRECT REF # TO LINK CERT	☒ N	HEAT# 852198
CORRECT MATERIAL IDENTIFICATION	☒ N	D6201
CORRECT M# ON THE MATERIAL	☒ N	161850
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>9-89</u> DATE: <u>17/06/16</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIREMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART RELEASED M-DRAWING
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING FOR NEW MATERIAL ONLY

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHAT'S CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER